

MAY 13 2015

Work Order ID 132295

132295

Page 1

Item ID: D2569

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hinge

Start Date: 5/06/15 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/15/15 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2569	Rev B
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100	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
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100

Powdercoat

Powder Coating

Memo M 131545.

0.00

Note: Advise that hinges are to be broken back and forth immediately after to ensure free mobility of hinge.

START TIME:

2:20

OVEN TEMPERATURE:

1400°

FINISH TIME:

2:50

5x ϕ 15-5-11 33 33 33

110

QC3- Inspect Part Finish

0.00

110

QC

Quality Control

Memo

0.00

(5)

DAS
38
9-89

MAY 12 2015

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May-06-15 11:26:10 AM

132295

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Item ID: D2569 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge
 Start Date: 5/06/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 5/15/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>PA</u>	0.00				5	DAS 27 5-23		
120									
Packaging	Memo	0.00							
Packaging									
									MAY 14 2015
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00				MLJ			MAY 15 2015
Quality Control									
									MLJ MAY 14 2015

Picklist Print

May-06-15 11:26:09 AM

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Work Order ID: 132295

132295

Parent Item: D2569

D2569

Parent Item Name: Hinge

Start Date: 5/06/15

Required Date: 5/15/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP D01.12.17Changed processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200		Purchased	No			100	f	22.6530	6	30			
MS20257-3-7200										**		15-5-6.	DAS 34 9:48
PIANO HINGE													

Location

Loc Qty

Loc Code

GA

0.853

m128923

0.853

ST479a

21.8

m131340 ✓

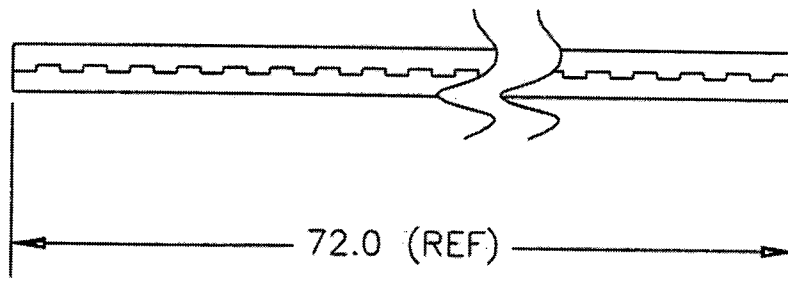
21.8

30'



DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>PA</i>	DRAWING NO. D2569	REV. B SHEET 1 OF 1
DATE 99.01.05		TITLE HINGE	SCALE 1:4
A	96.06.24	NEW ISSUE	
B	99.01.05	ADDED MS20257-3-7200 AND P/C REMOVED HOLE PATTERN	

RELEASED
49.01.21 KE



W/O 132295

NOTES:

- 1) MAKE FROM MS20257-3-7200
- 2) POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ENSURE HINGE MOVEMENT IS MAINTAINED IMMEDIATELY AFTER POWDER COAT
- 4) USE 0.040 LOCKWIRE TO SECURE HINGE PIN AT BOTH ENDS (USE #60 DRILL FOR LOCKWIRE HOLE)